

Date: Monday, 6/5/2006 7:41:05 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 27342		Part Number	: D3140101	
Estimate Number	: 11471		Drawing Number	: D3140 REV D1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: D1	
Prsh't Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : MACHINED PARTS		Due Date	: 6/30/2006 Qty: 6 Um: Each	
Previous Run	: 26723				
Written By	: <u>Skyy</u> Comment Below				
Checked & Approved By	: <u>SKYY</u> 06.06.05				
Comment	: Est. A 02.04.30 New Issue NG				
	: Est. B 06.04.18 New dwg rev. ecn781 EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet  Comment: Qty.: 0.0466 sf(s)/Unit Total : 0.2797 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick ( M2024T3S.032 ) 2.20" x 2.80" ref Note: Part not square. Batch <u>1100284</u> <u>06.06.06</u>
2.0	SHEAR Water jet	SHEAR  Comment: SHEAR Cut as per dwg D3140 Deburr. No sharp edges Prog Rev. <u>D1</u> Dwg Rev <u>D1</u> <u>06.06.06</u>
3.0	QC2	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP <u>06.06.06</u>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>06.06.06</u>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>06.06.06</u>

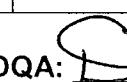
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No  DQA: 

Date: 06/06/12

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:41:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27342

Part Number: D3140101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA-10

CA-106109108 (6)

7.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/10 (6)

Job Completion



DL 06/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR NTS	
		A 02.04.18	NEW ISSUE
		B 03.01.23	REMOVE -65/-81/-83; ADD -301/-303
		C 04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°
		D 05.11.23	ADD -103/-104/-105/-106; REMOVE -67
		D1 <i>[initials] 06.03.31</i>	1.75 WAS 1.88; 4.75 WAS 4.13

RELEASED BY

05.12.01

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
		1	1			D3140-303	DOUBLER
						5	MS20426AD3-4
						5	RIVET

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NO. *27342*

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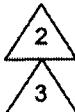
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED  
05-12-01-01



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

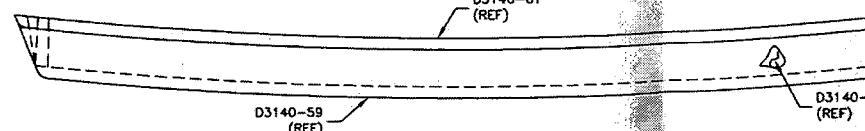
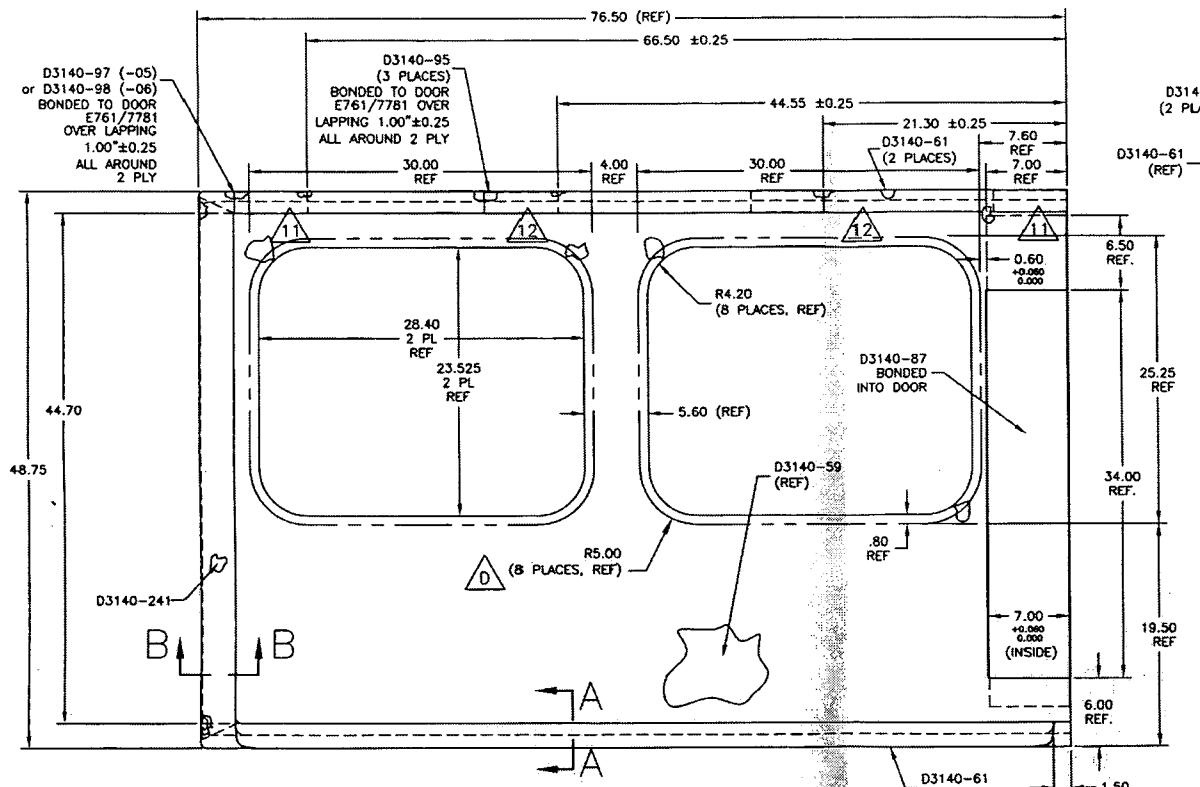


RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
(MAINTAINS & CUTOUTS TO BE LOCATED PER P/N B30-23000-011/-021 TOOL)



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DATE 05.11.23	TITLE DOOR		SCALE NTS

NO. 27342

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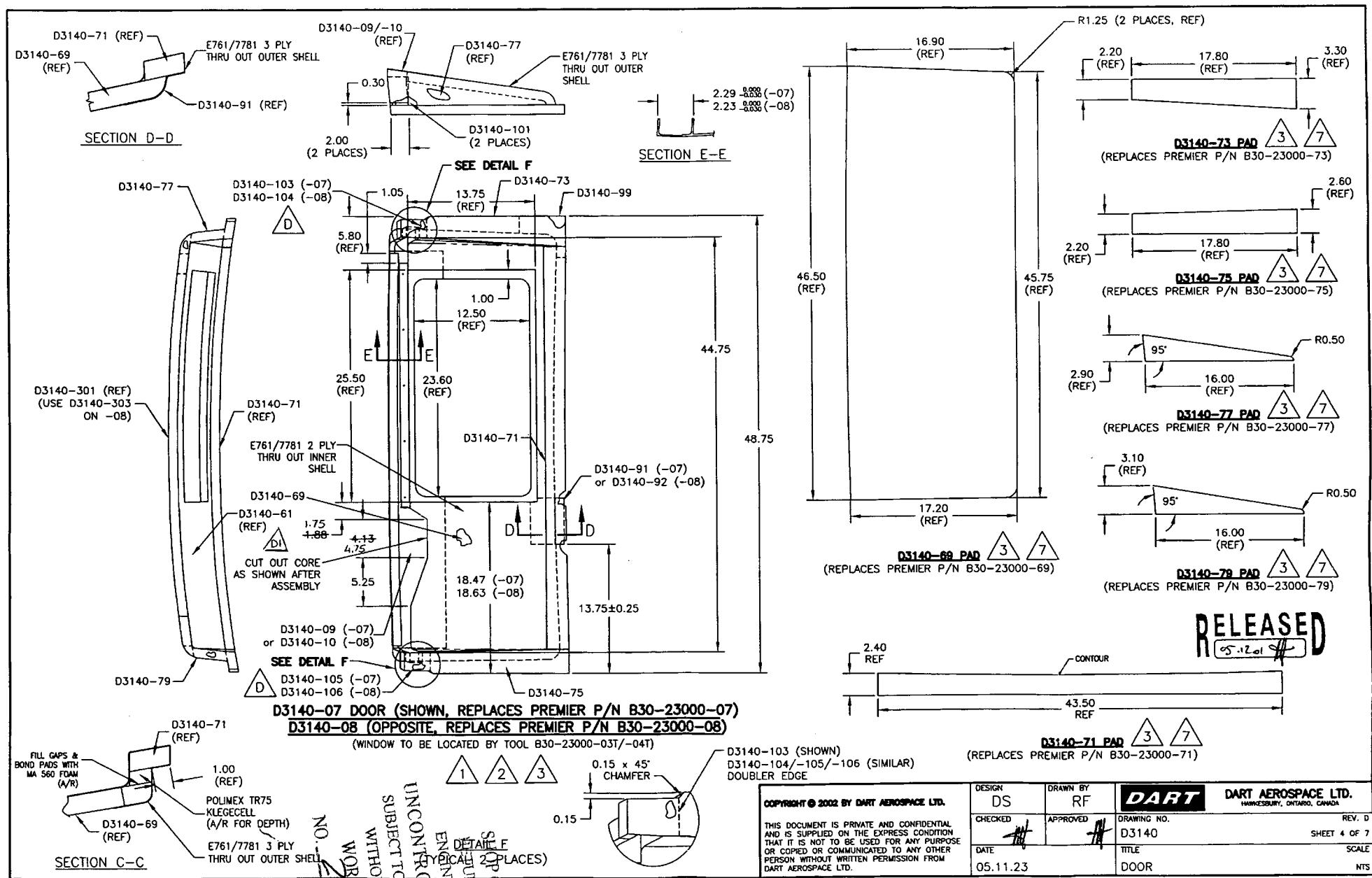
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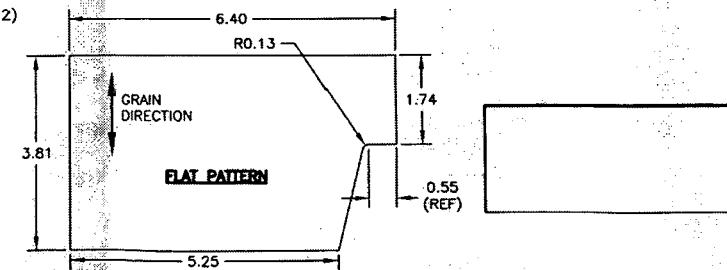
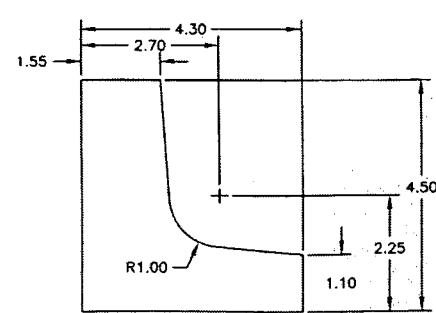
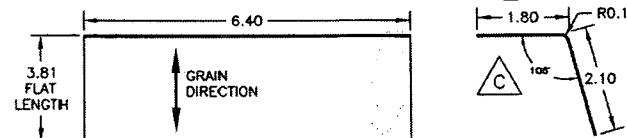
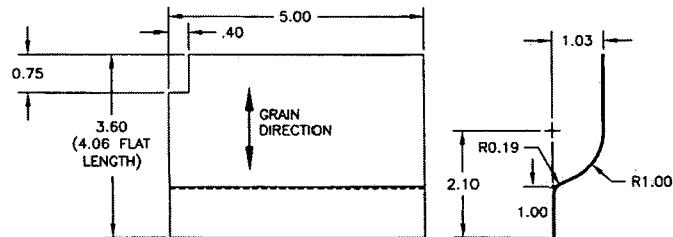
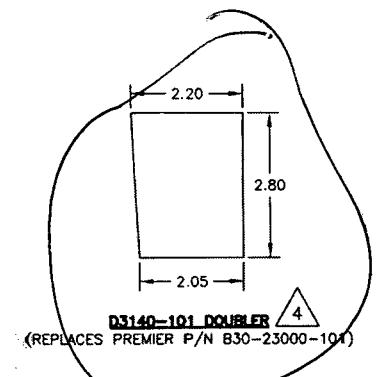
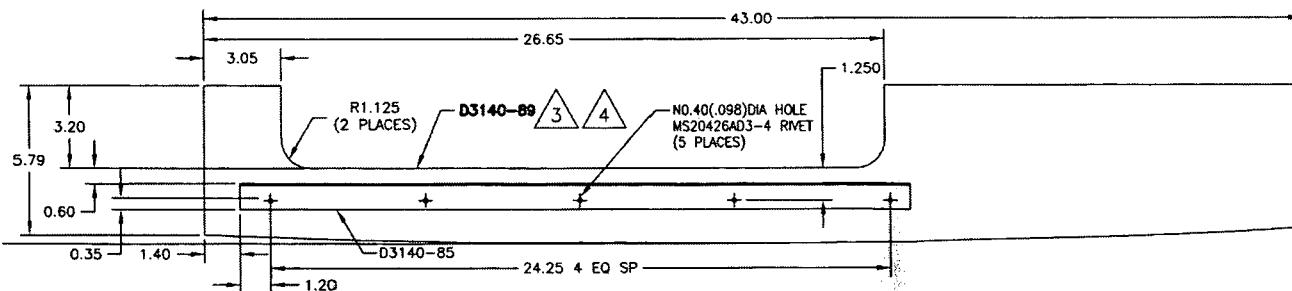
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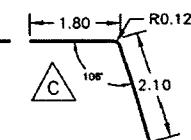
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SHEET 5 OF 7  
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DRAWING NO.

D3140

DATE

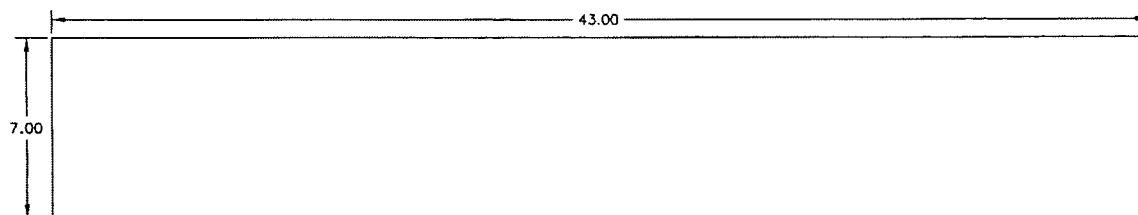
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TITLE

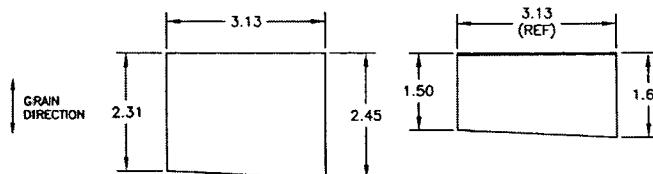
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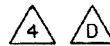


D3140-87 DOUBLER 4  
(REPLACES PREMIER P/N B30-23000-87)



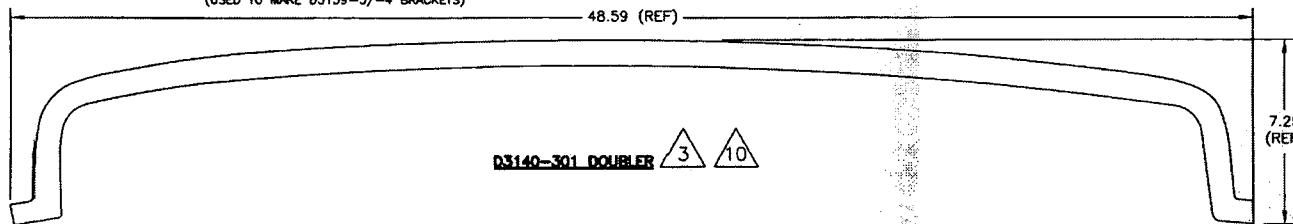
D3140-105F FLAT PATTERN  
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER  
D3140-106 OPPOSITE

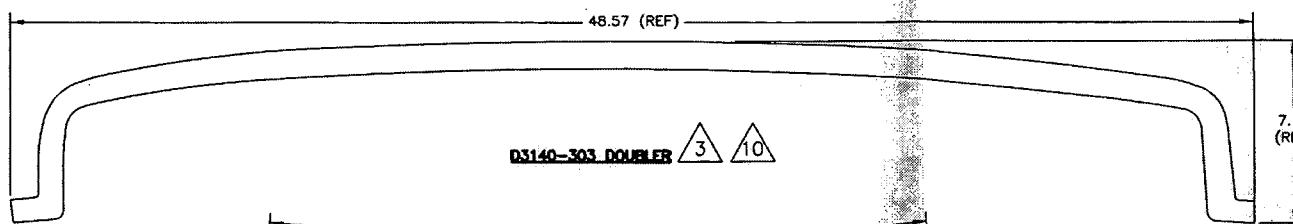


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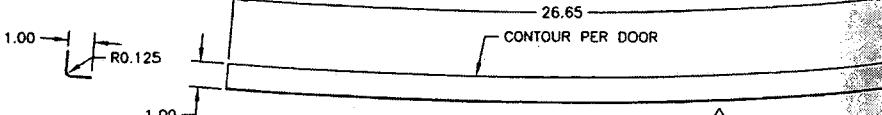
48.59 (REF)



D3140-301 DOUBLER 3 10



D3140-303 DOUBLER 3 10



D3140-85 ANGLE 6  
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

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SHEET 6 OF 7

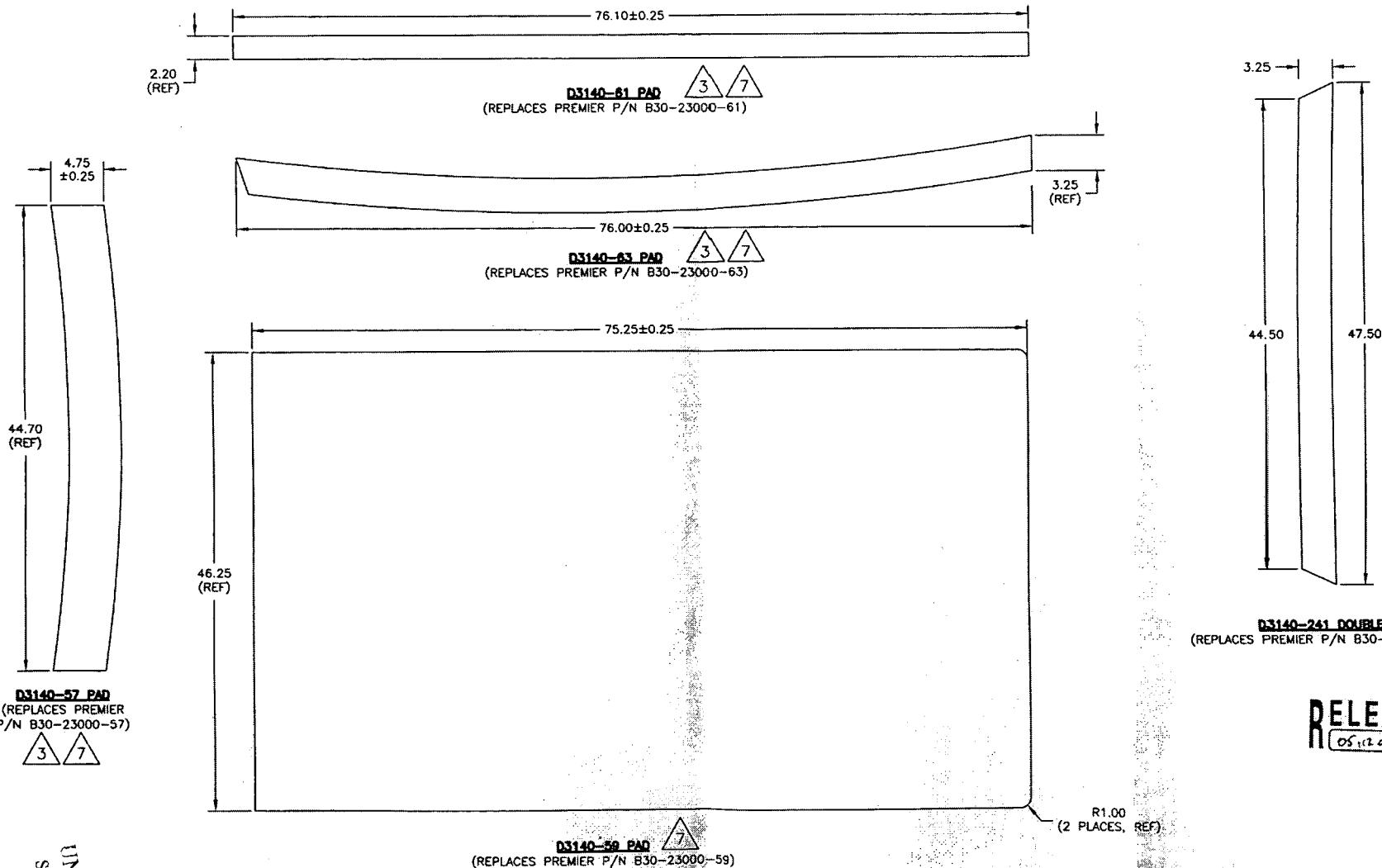
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D3140-59 PAD

(REPLACES PREMIER P/N B30-23000-59)

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DATE		TITLE	SCALE
05.11.23		DOOR	NTS

DART AEROSPACE LTD

**Work Order:**

07342

**Description:**

**Part Number:**

3140-101

**Inspection Dwg:**

**Rev:**

Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X | First Article

## X | Prototype

Measured by

**Audited by:**

### Prototype Approval:

Date: 01/06/07

Date: 11/20/09

Date: \_\_\_\_\_

Rev.	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	

